

Work Order ID 72136

Tuesday, July 19, 2011 12:44:28 PM



Page 1

Item ID: D2876

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 7/19/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

11-07-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2876

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D 2876 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

6061 .100

11-8-10

(44)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-8-10

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 x 10 & 14

counted

(44)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2876

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 7/19/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Remove tabs and Tumble								
140		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									

41 of 400811

41 X of 400811

W/O:		WORK ORDER CHANGES					
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Item ID: D2876

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 7/19/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 025

0.00



Packaging

Memo

0.00

Packaging

Pass 12 (44)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/12

11/08/12
(44)

Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Tuesday, July 19, 2011 12:44:33 PM

Work Order ID: 72136



Parent Item: D2876



Parent Item Name: Saddle Spacer

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: Esr Rev:B 00.05.19 Added inspect level 8 EC
IPP Rev:C Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.100		Purchased	No			100	sf	26.4000	0.0516	2.172632		2-5	
											B11-8-10		

6061-T6 .100 Sheet

Location

Loc Qty

Loc Code

MAT021

26.4

102201

1

118072

25.4

118072

44

Dart Aerospace Ltd

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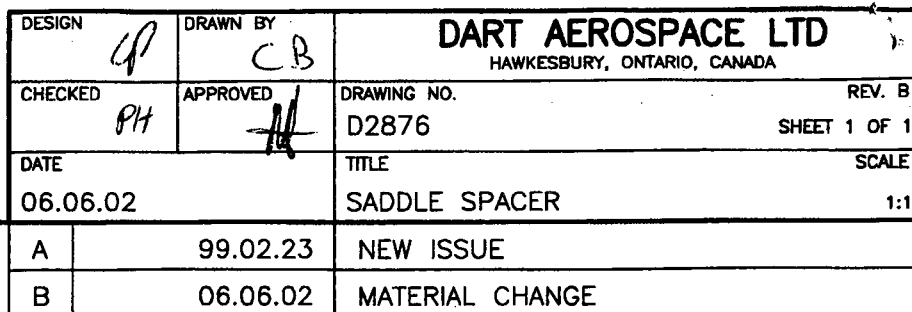
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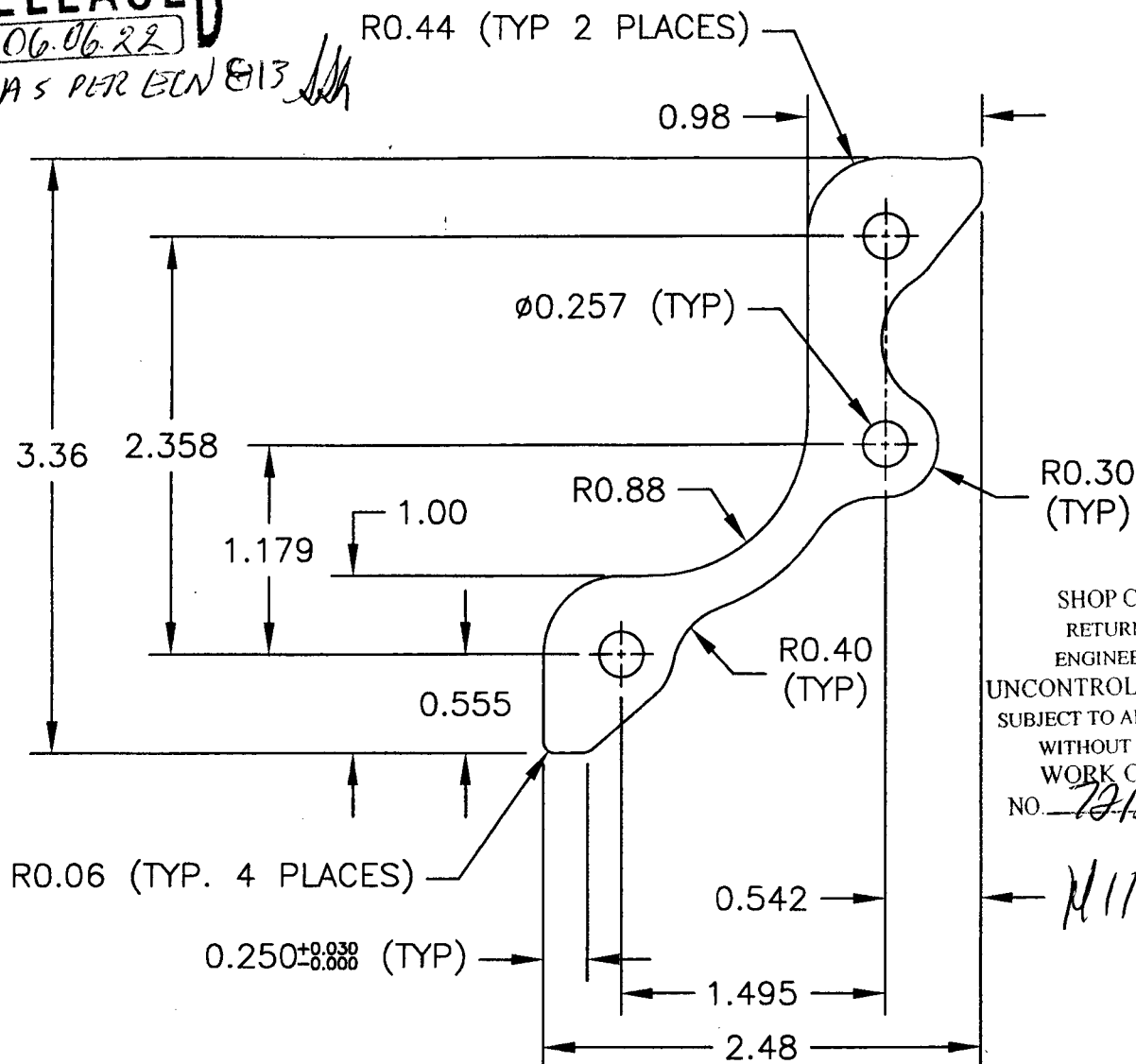
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AS PER ECLN 913



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72134

11-07-09

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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